

Process Sheet

Customer	: CC-DAR01 Dart Aerospace Ltd.		Drawing Name	: REWORK D2972 TO D3864-1	
Job Number	: 43921		Part Number	: D38641	
Estimate Number	: 10804		Drawing Number	: ECN08-573P	
P.O. Number	:		Project Number	:	
This Issue	: 04/12/2008	S.O. No. :	Drawing Revision	:	
Prsht Rev.	: NC		Material	:	
First Issue	: / /	Type : MACHINED PARTS	Due Date	: 05/12/2008	Qty: <i>70</i> Um: Each
Previous Run	: 00015				
Written By	:				
Checked & Approved By	: <i>U</i>				
Comment	:				

Additional Product

~~PRELIMINARY ISSUE~~

*#
08.12.08
SEE RELEASED
DRWG*

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	PACKAGING 1	PACKAGING RESOURCE #1 <i>Comment: PACKAGING RESOURCE #1</i> <i>As 12.08</i> <i>PULL FROM STOCK:</i> <i>70 - 60 X D2972 B 42268</i>
2.0	D2972	Bushing <i>Comment: Qty.: 1.0000 Each(s)/Unit Total : 60.0000 Each(s)</i> <i>Bushing</i>
3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE <i>Comment: CONVENTIONAL MILLING MACHINE → cobra</i> <i>RE-MACHINE PER DRWG D3864 REV.A J.F. 08/12/08 PER ECN 08-573P 69 pcs</i>
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE <i>Comment: INSPECT PARTS AS THEY COME OFF MACHINE</i> <i>J.F. 08/12/08</i>
5.0	QC8	SECOND CHECK <i>Comment: SECOND CHECK</i> <i>08.12.08 for QSP019 69</i>

ENGINEERING

APPROVAL

08.12.08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3864-1 (DZ972) PAR #: NIA Fault Category: Design NCR: Yes No DQA: SD Date: 08/12/05
 QA: N/C Closed: SD Date: 08/12/05

NCR: 43921		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08/12/05	3.0	Wall thickness not uniform. Difference of .012 due to set up in manual lathe as per work order specifications. Used Cobra for remaining work.	ASL	Qty 1 part scrap.	08/12/05	08/12/05	08/12/05	08/12/05
		R.C: New process for BCU17 NCR 08-115.						

NOTE: Date & initial all entries

Date:

Thursday, 04/12/2008 3:18:40 PM

User:

Linda Lacelle

Process Sheet

Customer: CC-DAR01 Dart Aerospace Ltd.

Drawing Name: REWORK D2972 TO D3864-1

Job Number: 43921

Part Number: D38641

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 PACKAGING 1

PACKAGING RESOURCE #1



08.12.16 (LB)



Comment: PACKAGING RESOURCE #1

U 08.12.16 (LB) NOTE: QTY(1) USED FOR TESTING PER 08.12.10

ID & STK

7.0 QC21

FINAL INSPECTION/W/O RELEASE



08/12/16 (LB)

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion

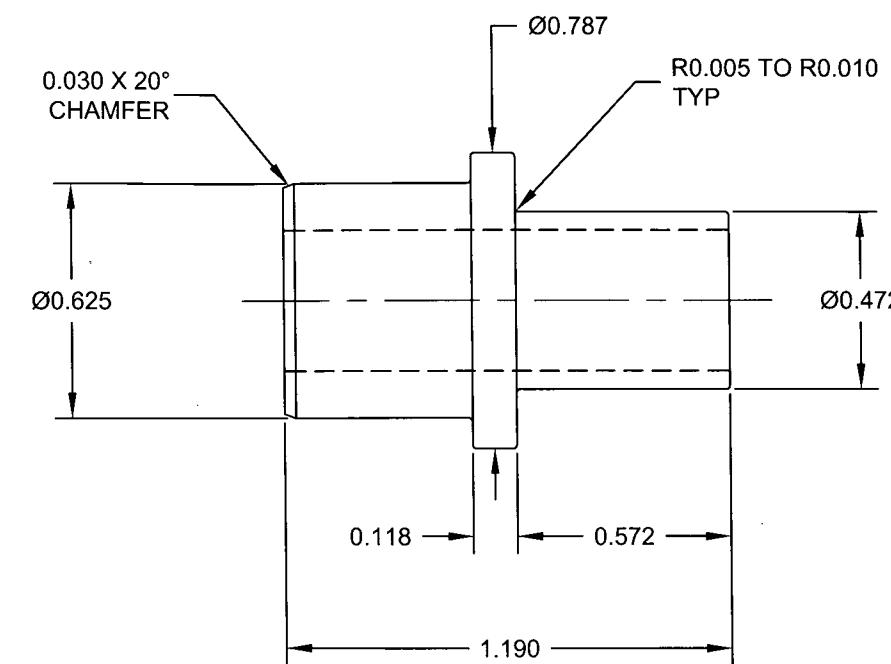


U 08.12.16

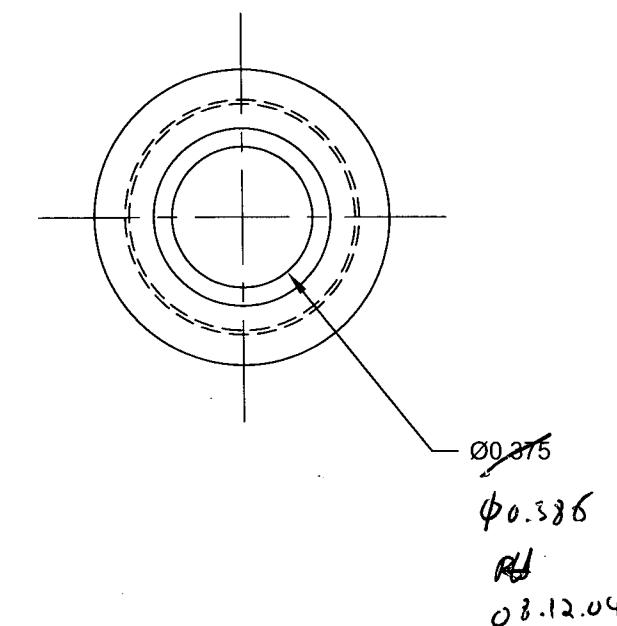
POSITIVE RECALL

EFFECTIVE 08.12.04 AUTH (LB)

RELEASED 08.12.16 DATE 08.12.16



D3864-1 BUSHING



NOTES:

- 1) MATERIAL: AISI 303 ROUND BAR
(DART SPEC M303RX.XXX)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.010 TO 0.020 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A

A	NEW ISSUE	PH	08.12.04
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>PH</i>	DART AEROSPACE USA, INC PORT HADLOCK, WA	
DRAWN	<i>PH</i>		
CHECKED	<i>A</i>	DRAWING NO.	REV. A
MFG. APPR.		D3864	SHEET 1 OF 1
APPROVED	<i>MP</i>	TITLE	SCALE
DE APPR.		BUSHING	NTS
DATE	08.12.04	© 2008 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

PRELIMINARY ISSUE
PH 08.12.04

DART AEROSPACE LTD	Work Order:	42268
Description: Bushing	Part Number:	D2972
Inspection Dwg: D2972	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

First Article Prototype

Dim change per
03864-1 per ECA
06-573P.

See attached

U
J
08.12.05

Measured by: <u>MMF</u>	Audited by: <u>Y.A</u>	Prototype Approval: N/A
Date: <u>08/12/07</u>	Date: <u>09/10/07</u>	Date: N/A

Rev	Date	Change	Revised by	Approved
A	07.11.23	New Issue	KJ/EC/DD	JK



1 COPY ISSUED

DESIGN RF	DRAWN BY RF	DART AEROSPACE USA, INC. BELLEVUE, WA
CHECKED #	APPROVED #	DRAWING NO. D2972
DATE 00.03.13		TITLE BUSHING
		SCALE 2:1

REV. A

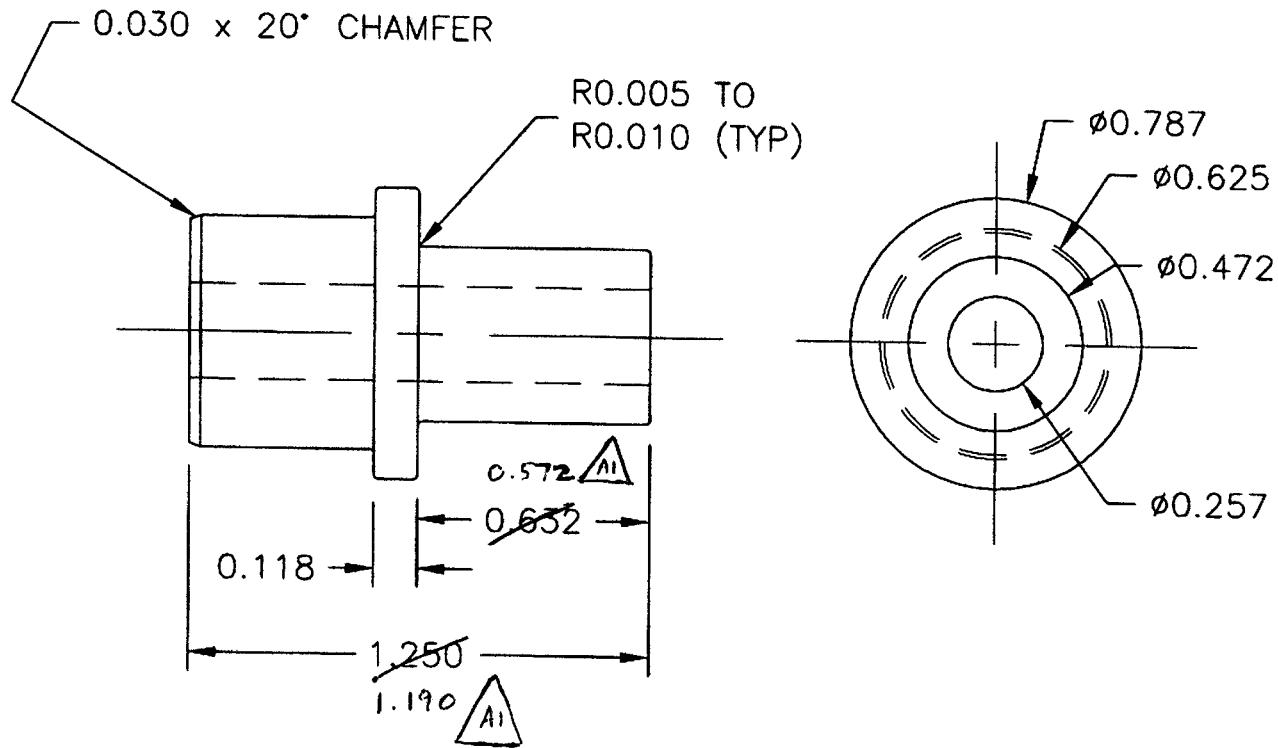
SHEET 1 OF 1

A

00.03.13

NEW ISSUE

RELEASED
00.05.11



REFERENCE ONLY

MATERIAL: AISI 303 STAINLESS STEEL
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
RADII ALL INSIDE EDGES 0.005 TO 0.010
BREAK ALL UNMARKED SHARP EDGES 0.010 TO 0.020
ALL DIMENSIONS ARE IN INCHES

A1 01.03.12 REDUCE LENGTH OF BUSHING A CP

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DART AEROSPACE LTD	Work Order:	43921
Description: Bushing / Preliminary	Part Number:	D3864-1
Inspection Dwg: D3864 Rev: A		Page 1 of 1

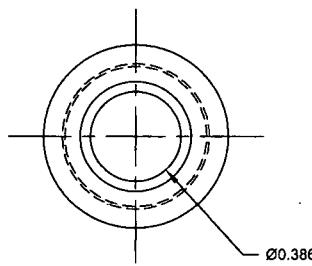
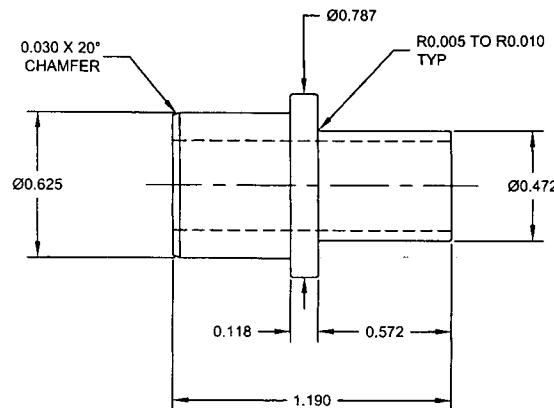
FIRST ARTICLE INSPECTION CHECKLIST

First Article

Prototype Preliminary

Measured by:	<u>CF</u>	Audited by:	<u>/</u>	Prototype Approval:	N/A
Date:	<u>08/11/05</u>	Date:	<u>08-12-05</u>	Date:	N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	



D3864-1 BUSHING

NOTES:

- 1) MATERIAL: AISI 303 ROUND BAR
(DART SPEC M303RX.XXX)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.010 TO 0.020 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.05 LBS

RELEASED
08.12.04

Mo 43921

A	NEW ISSUE	PH	08.12.04
REV.	DESCRIPTION	BY	DATE
DESIGN	PH	DART AEROSPACE USA, INC	
DRAWN	PH	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3864	SHEET 1 OF 1
APPROVED		TITLE	SCALE
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